| | | | | _ | | | | | | DQA: | Date: | |
|---------------|-------------|---------------------------------------|----------|----------|----------------------------|-------------------------------------|----------|-------------------------|----------|---------------|---------------|--------------------|
| NCR: | es / No | | | | WORK ORDER NON-C | 100 | VFOR | MANCE / UPDATE | | | | |
| | | | | | | | | | | QA Closed: | Date: | |
| Work Orde | ar. | | | | DISPOSITION | | | AGAIN | ST DE | PARTMENT | /PROCESS | |
| WOIR OIG | -''- | | • | | Rework | ı | | Skid-tube Crosstu | he | 1 | Water Jet | Engineering |
| Part N | lo. | | | | Scrap | | | Machining Small F | | Pro | d. Eng. Coor. | Quality |
| | | · · · · · · · · · · · · · · · · · · · | | | Use-as-is | | | noforming Finishi | — | 4 | re/Packaging | Other |
| NCR N | lo | * | | | Work Order Update | | | Large Fab Composi | te | | Supplier | |
| | | | | | | | | | | | | |
| Root | | | | ł | ption of work order update | | nitial | Action | | Sign & | | |
| Cause | Date | Step | Qty | (| or Non-conformance | Ch | ief Eng | Description | | Date | Verification | QC Inspector |
| Doc/Data | _ | | | | | | | | | | | |
| Equip/Tooling | _ | | | 1 | | 1 | | | | | · | |
| Operator | _ | | | | | | | | | | | |
| Material | _ | | | | <i>d</i> , | | | | | | : | |
| Setup | | | | | | | | | | | | |
| Other | | | | | | | | | | | | |
| Process | | | | | | | | | | | | |
| Supplier | | · 1 | | | | | | | | | | |
| Training | | | | | | | | | | | | |
| Unapproved | | | 1 | <u></u> | | <u> </u> | | | | | | |
| | | | | | F | AUL | T CATE | GORY | | | <u> </u> | |
| Landi | ng Gear | | | _ | General | | 1 | | _ | . | _ | 7 |
| | Bendin | - | | | Bend | | Grain | | | Ovalized | <u> </u> | Pressure/Forced |
| | | Not Conce | ntric to | o/s | BOM/Route | $ldsymbol{ldsymbol{ldsymbol{eta}}}$ | Hardwa | | | Over/Under | | Temperature/Cure |
| | Cracks | | | <u> </u> | Broken/Damaged | | 1 | on Incomplete | | Part Incorred | - | Weld |
| | Crushe | d/Crimped | | | Burrs | | Instruct | ions Incomplete/Unclear | | Part Lost/Mi | ssing | Wrong Stock Pulled |
| | Cuffs | | | | Contamination | | Mainte | nance | | Part Moved | | |
| | Hoat Tr | oat | | i | Countersink | 1 | Mislahe | hal | | Positioned V | Vrong | |

Misread

Out of Calibration
Out of Sequence

Outside Dimensions

Offset

Other

Power Loss/Surge

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Inspection Strip in Tube

Torque Waves in Extrusion

Cut Too Short

Drill Holes

Drawing

Finish Folio

| Work Orde April-30-13 2:3 | | 1006 | | | *101 | 100 | 16* | | | | | | | Page 2 |
|---|----------------------------|---|-------------------|-----------------------|----------------------------|-----|----------------------|--------|--------------|---------------|------------|---------------|------------------|----------------|
| | D2150 Packer Doubl 4/30/13 | er, Hinge Start Qty: 20.00 | *2 | Ассер Р О * |)t | | V900 | | 100 |)* s | Setup | Start Stop | 1 11 | S1* S2* |
| Required Date: Reference: | 4/30/13 | Req'd Qty: 20.00 | *2 | PN* | | | Customer: | | | _ | | C 4 4 | • | |
| Approvals: | | an: | Date: | | oling: _ | | | ıte: | | R | Run | Start Stop | *N *N | R1* R2* |
| Sequence ID/ Work Center II 130 *120* Small Fab Small Fab | | Operation Description Small Fab Memo Deburr | | F 0.0 | Set Up/ Run Hours 00 | | Tool ID DAS 27 9-89 | Tool # | Plan Code | Accept Qty | Rej Qty | | Reject Number | Insp. Stamp |
| *140 *140* HandFinish Hand Finishing | | Chemical Conversion Coa | at per QS1005 4.1 | | .00 | | | | | 20 | J | DA | 9/3 | 918 |
| *150 *150* Powdercoat Powder Coating | , | White Gloss(Ref:4.3.5.1) Memo START TIME 3000 | E: | , CO, | 00 .00 N TEMPERATUR | RE: | | | | 2 ox | Ø-1 | M | L13 ₁ | 109/18 |

m126125

| NCR: | ⁄es | / No | | | | WORK ORDER NON-C | | NFORM | MANCE / UPI | DATE | | | |
|---------------|----------|-------------|------------|----------|----------|--|----------|---|-------------------|------------|--------------|--|---------------------------|
| | | | | | | | | | | | QA Closed: | Date | : |
| Work Orde | er: | | | | | DISPOSITION | | | | AGAINST DE | PARTMENT | /PROCESS | |
| Part N | ۰ ۱۵۰ | | | | | Rework Scrap Use-as-is Work Order Update | | Skid-tube Crosstube Machining Small Fab Thermoforming Finishing Large Fab Composite Initial Action | | | | Water Jet d. Eng. Coor. re/Packaging Supplier | Engineering Quality Other |
| Root | ſ., | | | | Descri | ption of work order update | 1 | nitial | Act | ion | Sign & | | |
| Cause | | Date | Step | Qty | | or Non-conformance | Ch | ief Eng | Descr | iption | Date | Verification | QC Inspector |
| Doc/Data | | | 1 | | | | | | | | | | |
| Equip/Tooling | | | <u>l</u> | | | | | | | | | i | |
| Operator | | | 1 | | | | | | | | | | |
| Material | | | | | | | | | | | | | |
| Setup | | | | · . | | | | | | | | | |
| Other | | | | | 1 | | | | | | <u></u> | | |
| Process | | | | | | | 1 | | | | | | |
| Supplier | | | | | | | | | | | | | |
| Training | | | | | | | | | | | | | |
| Unapproved | L.,_ | , | | | | | | | | | | <u> </u> | |
| | | | | | | | AUL | T CATE | GORY | | | | |
| Landi | | 1 | | | _ | General | | • | | | 1 | - | _ |
| | | Bending | | | | Bend | <u> </u> | Grain | | | Ovalized | <u>_</u> | Pressure/Forced |
| | | Centre No | ot Concei | ntric to | o/s | BOM/Route | _ | Hardwa | | | Over/Under | | Temperature/Cure |
| | | Cracks | | | <u> </u> | Broken/Damaged | | Inspecti | on Incomplete | | Part Incorre | ct _ | Weld |
| | _ | Crushed/ | Crimped | | | Burrs | | 1 | ions Incomplete/U | Inclear | Part Lost/M | issing | Wrong Stock Pulled |
| | ⊢ | Cuffs | | | | Contamination | | Mainte | | <u></u> | Part Moved | | |
| | ⊢ | Heat Trea | | | <u> </u> | Countersink | \vdash | Mislabe | | <u></u> | Positioned V | | _ |
| | \vdash | Inspectio | • | Tube | | Cut Too Short | <u></u> | Misread | I | | Power Loss/ | Surge | Other |
| | | Ripples in | | | | Drill Holes | L | Offset | | | | | |
| | | Torque W | /aves in E | xtrusio | n [| Drawing | [. | Out of 0 | Calibration | | | | |

Out of Sequence

Outside Dimensions

DQA:

Date:

Turning Sequence

Wave/Twist in Tube

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

| Work Ord April-30-13 2:. | | 01006 | · | *101 | | | | | Page | | | |
|--|---------------------|--|--------------------|----------------------|--------------|-------|--------------|----------------|--------------|---------------|------------------|----------------|
| Item ID: Revision ID: | D2150 | | | Accept | *N900 | 040 | 100 |)* | Setup | Start | *N | S1* |
| Item Name: Start Date: Required Date | Packer Doub 4/30/13 | Start Qty: 20.00 Req'd Qty: 20.00 | *20* | | Cust Item II | D: | | | | Stop | *N | S2* |
| Reference: | . 4/30/13 | Key u Qiy. 20.00 | *20* | | Customer: | | <u></u> | | D | Stant | | _ : . |
| Approvals: | | an: | Date: | Tooling: SPC (Y/N): | | ite: | | | Run | Start Stop | *N *N | R1* R2* |
| Sequence ID/ Work Center I | D | Operation Description QC3- Inspect Part Finish | | Set Up/ Run Hours | Tool ID | Tool# | Plan Code | Accep Qty | t Rej Qty | | Reject Number | Insp. Stamp |
| *160* QC Quality Control | | Мето | | 0.00 | | | | 2 _x | _ <i>\$</i> | 9 | 13 | locel |
| 170 * 17 0* | | Identify as per dwg & Stoo | ck Location: 8700S | 0.00 | | | | 20) | | | | S |
| Packaging Packaging | | Memo | | 0.00 | | | | | | | | 39 |

0.00

0.00

QC21- Final Inspection - Work Order Release

Memo

180

120

Quality Control

Page 3

| NCR: Y | es / No | | | | WORK ORDER NON- | CONFOR | MANCE / UP | DATE | | | |
|------------|----------|-------------|------------|--------|----------------------------|-----------|-------------------------------|-------------------------------|---------------|---------------------------------------|---------------------------|
| | | | | | | | | | QA Closed: | Date | : |
| Work Orde | r: | _ | | | DISPOSITION | , | | AGAINST DE | PARTMENT, | _ | |
| Part N | o | | | | Rework Scrap Use-as-is | Ther | Skid-tube Machining moforming | Crosstube Small Fab Finishing | 1 | Water Jet od. Eng. Coor. re/Packaging | Engineering Quality Other |
| NCR N | 0 | | | | Work Order Update |] | Large Fab | Composite | | Supplier | |
| Root | | | | Descri | ption of work order update | Initial | Ac | tion | Sign & | | |
| Cause | Date | Step | Qty | | or Non-conformance | Chief Eng | g Desc | ription | Date | Verification | QC Inspector |
| oc/Data | _ | | | | | | | | | | |
| perator | _ | | | | | | | | | | |
| //aterial | 7 | | | | | | | | | | |
| etup | _ | | | | | | | | | | |
| Other | 1. | | | | | | | | | | |
| rocess | 7 | | | | | | | | | | |
| upplier | | ļ | | | |] | | | | | |
| raining | | | | | | | | | | | |
| Inapproved | | | | | | <u> </u> | | | | | |
| | | | | | F | AULT CAT | EGORY | | | | |
| Landin | ng Gear | | | | General | | | | _ | _ | _ |
| | Bending | | | | Bend | Grain | | | Ovalized | | Pressure/Forced |
| | Centre N | Not Conce | ntric to (| o/s | BOM/Route | Hardw | are | | Over/Under | tolerance | Temperature/Cure |
| | Cracks | | | | Broken/Damaged | Inspec | tion Incomplete | | Part Incorred | ct _ | Weld |
| | Crushed | /Crimped | | L | Burrs | instruc | ctions Incomplete/ | Unclear | Part Lost/Mi | issing | Wrong Stock Pulled |
| | Cuffs | | | | Contamination | Maint | tenance | | Part Moved | | |
| | Heat Tre | eat | | | Countersink | Mislab | eled | | Positioned V | Vrong | - |
| ļ | Inspecti | on Strip in | Tube | L | Cut Too Short | Misrea | ad | | Power Loss/ | Surge | Other |
| Ĺ | Ripples | in Bend | | | Drill Holes | Offset | | | | | |
| | Torque ' | Waves in B | Extrusio | 1 | Drawing | Out of | Calibration | | | | |
| | Turning | Sequence | ! | | Finish | Out of | Sequence | | | | |

Outside Dimensions

DQA:

Date:

Wave/Twist in Tube

Folio

Picklist Print

April-30-13 2:38:08 PM

Work Order ID:

101006

Parent Item:

D2150

Parent Item Name:

Component Item ID/

Packer Doubler, Hinge

Replacement

Item ID

Comments:

Item Name

M2024T3S.040

IPP C00.11.27Re-format (mpp 2101)EC

IPP Rev:D 06-08-23 Now on Waterjet Mfg/

Purch

Purchased

Bin

Item

No

| JLM | | | | | | | | | |
|---------------------|------------------|-----------------|--------------------|----------|-------------|--------------|---------------|----------------|-----------|
| Primary Location | Last Location | Route Seq ID | Unit of Measure | | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
| | | 100 | sf | 458.6877 | 0.025 | 0.5263T58 | | Sm | 13-09-16. |

Start Date: 4/30/13

Start Qty: 20.00

2024-T3 .040 sheet

Location Loc Qty Loc Code MAT022 458.6876922 120605 65.8254832 121197 57.187894 122136 31.78 24.394315 123217 124987 279.5

124987

Page 1

Required Date: 4/30/13

Required Qty: 20.00

| | | | • | | | | | | | | | DQA: | Dat | te: | |
|------------------------------------|----------|------------|-----------|----------|------|---------------|------------------------------|----------|----------|-------------------------------|-------------------------------|---------------|--|---------------|---------------------------|
| NCR: | ⁄es | / No | | | | | WORK ORDER NON- | COI | NFORM | MANCE / UP | DATE | | | | |
| | | | | | | | | | | | · | QA Closed: | Dat | te: | |
| Nork Orde | er: | | | | | | DISPOSITION | | | | AGAINST DE | PARTMENT | /PROCESS | | |
| Part f | No. | | | | | | Rework Scrap Use-as-is | | 1 | Skid-tube Machining Moforming | Crosstube Small Fab Finishing | 4 | Water Jet d. Eng. Coor. re/Packaging | | Engineering Quality Other |
| NCR I | No. | | | | | | Work Order Update | | | Large Fab | Composite |] | Supplier | | |
| Root | | | | | Desc | crip | tion of work order update | l | nitial | Act | tion | Sign & | | | |
| Cause | | Date | Step | Qty | | 0 | r Non-conformance | Ch | ief Eng | Desci | ription | Date | Verification | n | QC Inspector |
| oc/Data quip/Tooling perator | | | | | | | | | | | | | | | |
| laterial . | | | | | | | | | | | | | | 1 | |
| etup | | 1 | | | | | | | | | | | | | |
| ther | | 1 | | | i | | | | | | | | | | |
| rocess | |] | | | | | | | | | | | | | |
| upplier | | | | | | | | | | | | | | | |
| raining | |] | | | | | | | : | | | | | | |
| Inapproved | | | <u> </u> | | | | | | | | | | | | |
| | | | | | | | F | AUL | T CATE | GORY | | | | | |
| Landi | ng (| Gear | | | - | | General | | | | | • | , | | |
| | | Bending | | | | - | Bend | | Grain | | | Ovalized | | - | Pressure/Forced |
| | _ | Centre No | ot Concer | ntric to | o/s | $\overline{}$ | BOM/Route | L | Hardwa | | | Over/Under | | $\overline{}$ | Temperature/Cure |
| | <u> </u> | Cracks | | | 1 | | Broken/Damaged | | 1 ' | on Incomplete | | Part Incorred | | —— | Weld |
| | _ | Crushed/ | Crimped | | | | Burrs | _ | 1 | ions Incomplete/l | Unclear | Part Lost/Mi | ssing [| | Wrong Stock Pulled |
| | | Cuffs | | | ļ | | Contamination | <u> </u> | Mainte | | <u> </u> | Part Moved | | | |
| | <u> </u> | Heat Trea | | | | | Countersink | | Mislabe | | <u> </u> | Positioned V | , , | | |
| | <u> </u> | Inspectio | - | Tube | | | Cut Too Short | <u></u> | Misread | • | | Power Loss/ | Surge | | Other |
| | L | Ripples in | | | | | Drill Holes | \vdash | Offset | | | | | | |
| | | Torque W | | | n | | Drawing | _ | 1 | Calibration | | | | | · |
| | 1 | Turning S | equence | | | | Finish | 1 | Out of S | equence | | | | | |

Outside Dimensions

Wave/Twist in Tube

Folio

| DART AEROSPACE LTD | Work Order: | 101006 |
|------------------------------|--------------|-------------|
| Description: Packer | Part Number: | D2150 |
| Inspection Dwg: D2150 Rev: A | | Page 1 of 1 |

FIRST ARTICLE INSPECTION CHECKLIST

| X First Article | Prototype |
|-----------------|-----------|
|-----------------|-----------|

| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|----------------------|---------------|---------------------|--------|--------|-------------------------|----------|
| 0.740 | +/-0.010 | 0.744" | - | | V | |
| 2.050 | +/-0.010 | 2054" | _ | | V | |
| 0.231 | +/-0.010 | 0.234" | _ | | V | |
| 1.217 | +/-0.010 | 1.320" | _ | | V | |
| 1.559 | +/-0.010 | 1.557 | _ | | V | |
| 2.300 | +/-0.010 | 2301" | - | | V | - |
| 1.560 | +/-0.010 | 1.564" | _ | | V. | |
| 0.250 | +/-0.010 | 0.753" | _ | | V | |
| 1.328 | +/-0.010 | 1.329 | - | | V | |
| 0.342 | +/-0.010 | 0.346 | _ | | V | |
| Ø0.098 | +0.005/-0.000 | 0.098" | - | | V | |
| Ø0.171 | +0.005/-0.000 | 0.171" | _ | | V | |
| 0.040 | +/-0.010 | 0.040" | | | V | |
| | | | | | .* : | , |
| | | | | | | |
| | | | | | | |
| | | | | | , | |
| | | | - | | | |
| | | | | | | |
| | | | | | | |
| | | | , | | - | |
| | | | | | | |
| | | | | | | |
| | | | , | - | · , | |

| | | | DAS | | |
|--------------|----------|-------------|------------|---------------------|-----|
| Measured by: | Jm | Audited by: | 27 9-89 | Prototype Approval: | N/A |
| Date: | 13-09-16 | Date: | 13 9 16 | Date: | N/A |

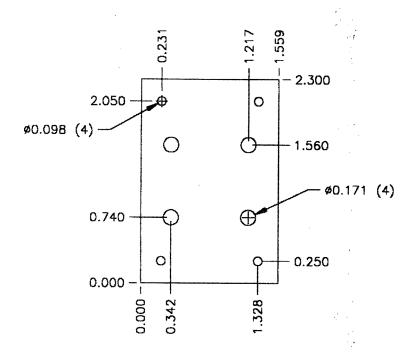
| Rev | Date | Change | Revised | by Approver | 8 |
|-----|----------|-----------|----------|-------------|---|
| A | 04.09.28 | New Issue | KJ/JLM « | XX GIII | |





| DESIGN B WILLIAMS | drawn by K HAND | DART AEROSPACE VICTORIA INTERNATIONAL AIRPORT, C | | | ******** |
|-------------------|--------------------|--|---|------|----------|
| CHECKED | APPROVED | DRAWING NO. | *************************************** | REV. | A |
| Bus | Bul | D2150 | SHEET | 1 OF | 1 |
| DATE | | TILE | | SCA | I.E |
| 95:05:01 | | PACKER | | | 1:1 |





Adolas espanholom INSURANGE VALUE AND LOSSES

MATERIAL: 2024-T3, 0.040 THICK FINISH: WHITE POWDER COAT HI-GLOSS